






Nad Jan 15



Work Order ID 64507



Page 1


Tuesday, December 07, 2010 9:07:23 AM

Item ID: D2282-7 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Tube
 Start Date: 12/7/2010 Start Qty: 300.00  Cust Item ID:
 Required Date: 1/21/2011 Req'd Qty: 300.00  Customer:
 Reference:

Approvals: Process Plan: PL Date: 12-7 Tooling: Date: Run Start 
 QC: Date: SPC (Y/N): Date: Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2282	Rev E

100	Hardinge CNC LATHE SMALL	0.00							
	Hardinge	Memo	0.00						
Hardinge CNC Lathe Small	1-Turn as per Dwg D2282 and Folio FA190 2-Deburr								


SL 10/12/13

336

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control									

SL 10/12/13

336

120	QC8- Inspect parts - second check	0.00							
	QC	Memo	0.00						
Quality Control									

SL 10/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2282-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Tube

Start Date: 12/7/2010 Start Qty: 300.00

Required Date: 1/21/2011 Req'd Qty: 300.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location *ewh*

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

12/16/10 *(3362)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/10 *[Signature]**U 10.12.10*

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Picklist Print

Tuesday, December 07, 2010 9:07:28 AM

Page 1

Work Order ID: 64507

Parent Item: D2282-7

Parent Item Name: Tube



Start Date: 12/7/2010

Required Date: 1/21/2011

Start Qty: 300.00

Required Qty: 300.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.675W.091

Purchased

No

100

f

42.1310

0.0666

21.03158



304 RD Tube .675 x .091W



SA 10/12/15

Location

Loc Qty

Loc Code

MAT

27.6

115180

27.6

MAT017 111456

14.531

~~111456~~

~~14.531~~

10.831

116386

10 RA

16 RA

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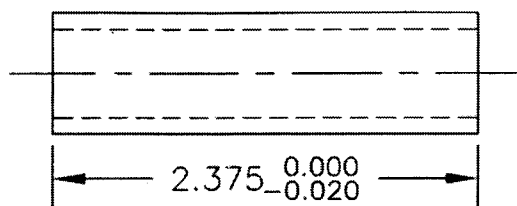
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

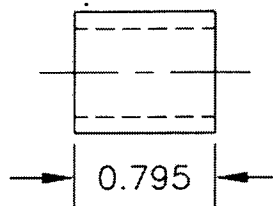


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

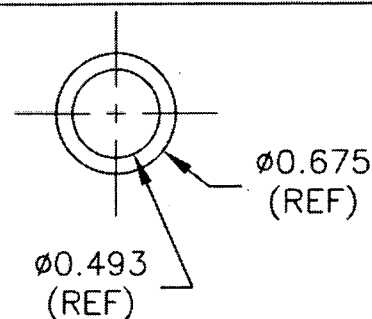
NO. 44307
BAC-2
RELEASED
BS/09/16



D2282-3

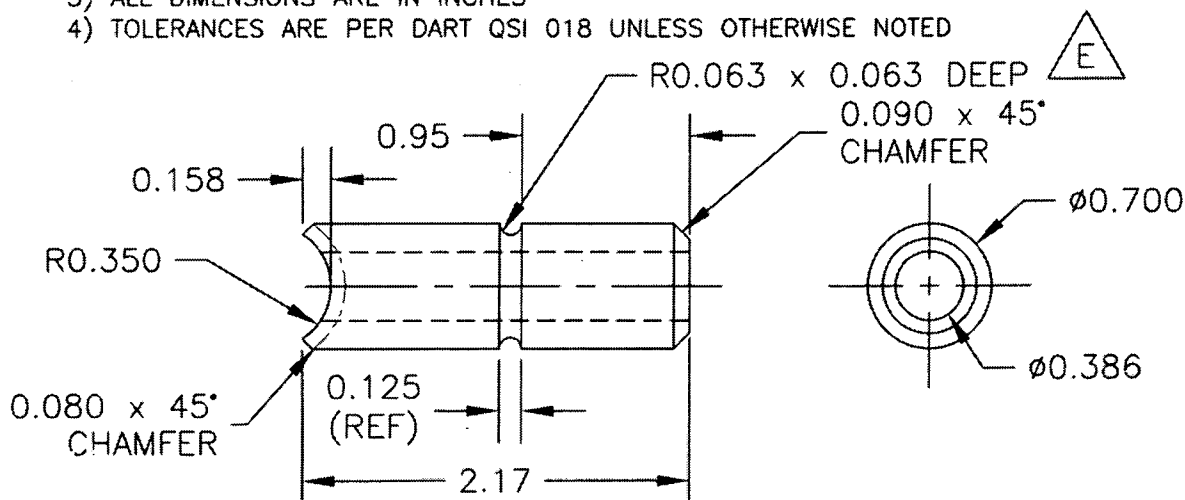


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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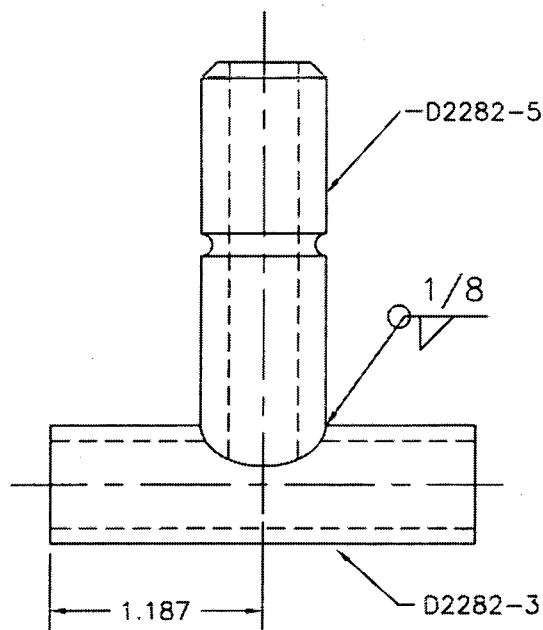
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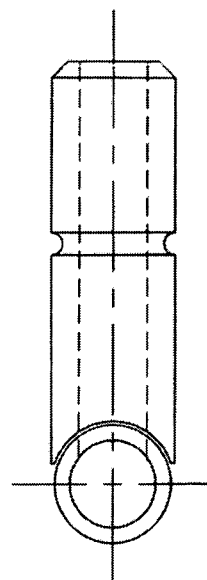
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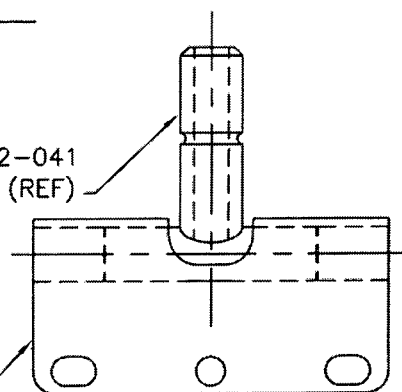
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



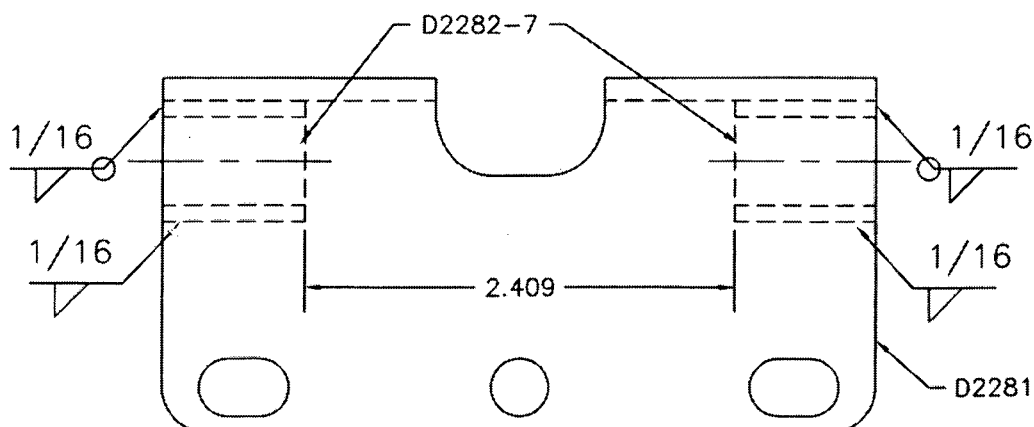
D2232-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-041
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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